

Work Order ID 150533

Thursday, August 25, 2016 10:38:04 AM

150533

Page 1

Item ID: D5208-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Guide

Start Date: 8/29/2016 Start Qty: 8.00 *24****8***
8 *24* *LM*

Cust Item ID:

Required Date: 9/19/2016 Req'd Qty: 8.00

Customer:

Reference:

Approvals:

Process Plan:

DAS
21
9-89

Date:

AUG 25 2016

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5208	B								<i>PR 2016/09/03</i>
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>3</u> Prog Rev: <u>3</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.01							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.03							
Quality Control									

24*PR 2016/09/03***DAS**
38
9-89

SEP 06 2016

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Item ID: D5208-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Guide
Start Date: 8/29/2016 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 9/19/2016 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	Form as per dwg NC BRAKE Memo	0.04 0.51				DAS 30 24 9-89			SEP 13 2016
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.03				24		DAS 38 9-89	SEP 14 2016
150 *150* Packaging Packaging	Identify as per dwg & Stock Location. <u>GA</u> Memo	0.00 0.01				24	DAS 6 9-89		SEP 15 2016

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Item ID: D5208-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Guide

Stop

NS2

Start Date: 8/29/2016 Start Qty: 8.00

g

Cust Item ID:

Required Date: 9/19/2016 Req'd Qty: 8.00

g

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.13

Quality Control

MUS 16-09-15

Picklist Print

Page 1

Thursday, August 25, 2016 10:38:08 AM

Work Order ID: 150533

150533

Parent Item: D5208-3

D5208-3

Parent Item Name: Guide

Start Date: 8/29/2016

Required Date: 9/19/2016

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 15.01.29 NEW ISSUE DD VERF:JLM IPP
REV:B 15.05.28 AS PER DWG REV.A DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S24GA		Purchased		No			sf	77.7490		0.555789			

M304S24GA

304/316 .025 Sheet

PR 2016/09/03

Location

Loc Qty

Loc Code

MAT020

64

m135275

64

MAT20

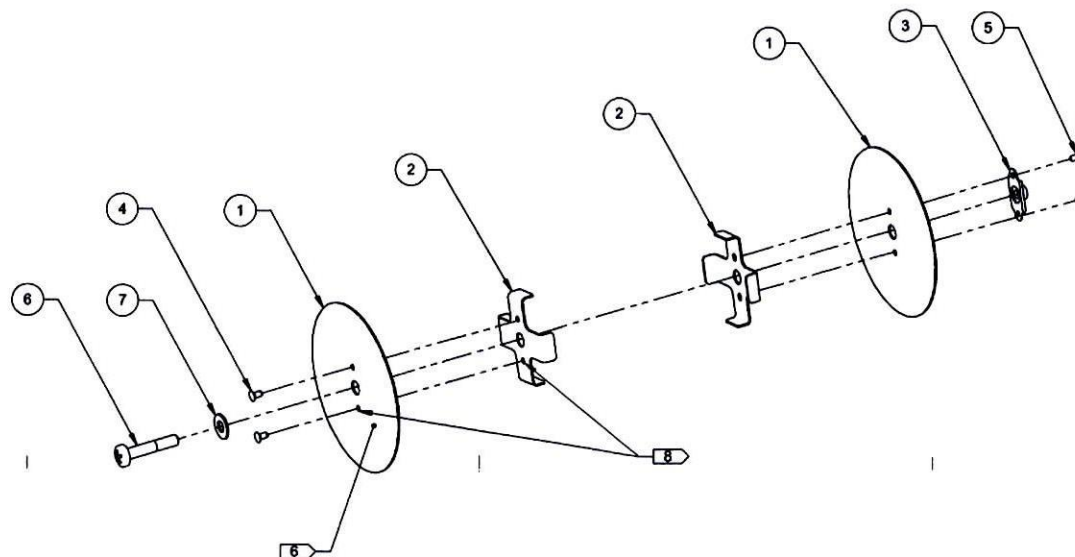
13.749

m134677

13.749

0.7

ITEM	QTY	P/N	DESCRIPTION
	X	D5208-041	BLANKING PLATE ASSY
1	2	D5208-1	BLANKING PLATE
2	2	D5208-3	GUIDE
3	1	FM5001-050	ANCHOR NUT, FLOATING
4	2	MS20427M3-3	RIVET, SOLID, CSK
5	2	MS20615-3M3	RIVET, SOLID, PAN-HEAD
6	1	LN9038-05-26	SCREW, PAN-HEAD
7	1	BS4320-A5	WASHER (ALT: BS4320-A-5, BS4320-AM5, NAS1149C0332R)



D5208-041 BLANKING PLATE ASSY

SHIP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 150533 MJS
160825

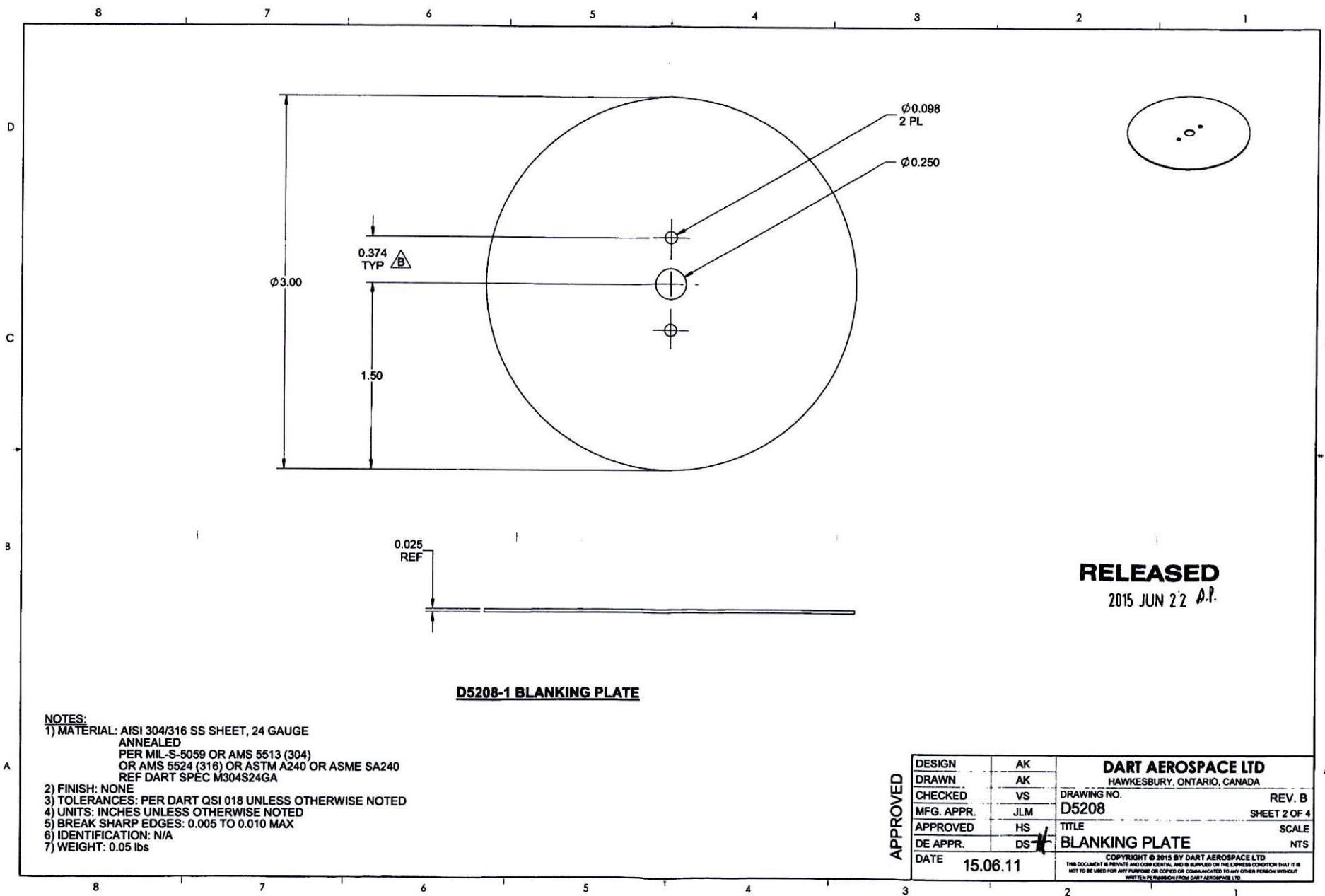
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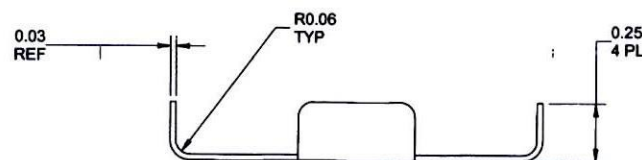
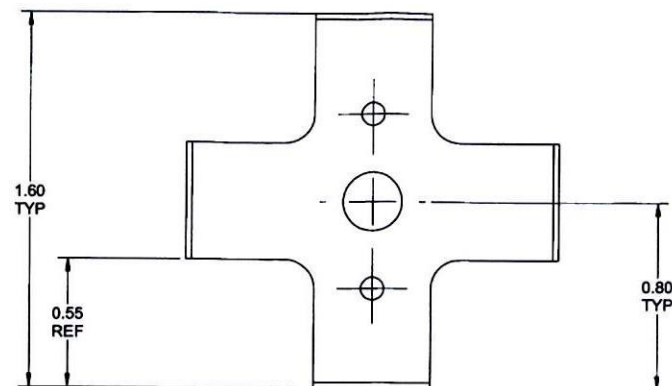
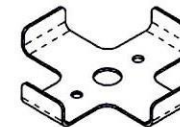
A7. 2015 JUN 22 EN 15-SBS

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.13 lbs
- 8) DIMPLE THIS FACE OF D5208-1/-3 PRIOR TO INSTALLING RIVETS

B	UPDATED HOLE LOCATION, 0.374 WAS 0.344 (ZN C6-2, ZN C2-4). ADDED ALTERNATIVE PART NUMBERS.	AK	15.06.11
A	NEW ISSUE	AK	15.01.13
REV.	DESCRIPTION	BY	DATE
DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JLM	D5208	SHEET 1 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BLANKING PLATE	NTS
DATE	15.06.11	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	





D5208-3 GUIDE

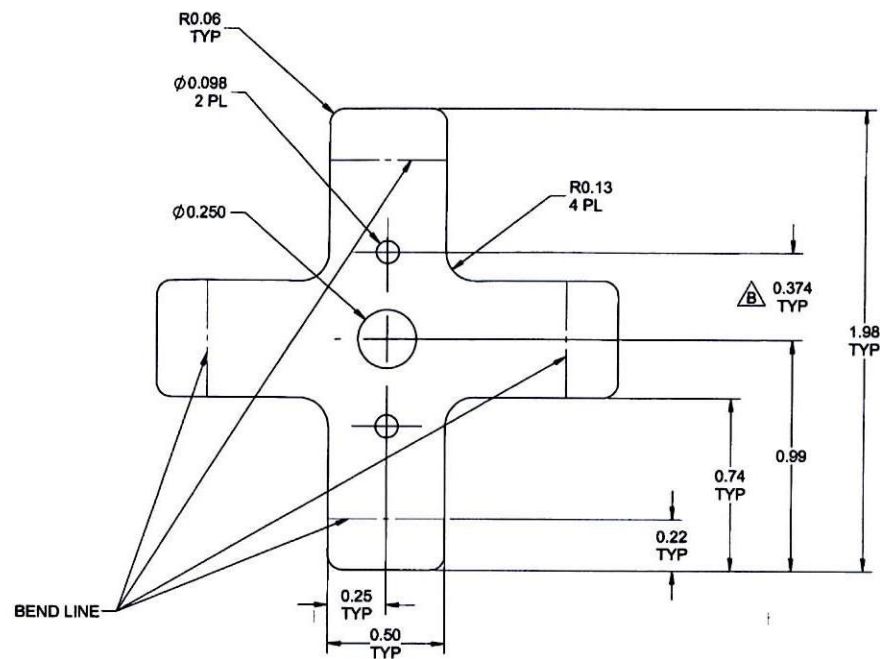
RELEASED
2015 JUN 22 *AR*

NOTES:

- 1) MATERIAL: MAKE FROM D5208-3F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

APPROVED

DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JLM	D5208	SHEET 3 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BLANKING PLATE	NTS
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D5208-3F FLAT PATTERN

RELEASED
2015 JUN 22 A.P.

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 24 GAUGE
ANNEALED
PER MIL-S-5059 OR AMS 5513 (304)
OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S24GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

APPROVED	DESIGN	AK	DART AEROSPACE LTD	
	DRAWN	AK	HAWKESBURY, ONTARIO, CANADA	
	CHECKED	VS	DRAWING NO.	REV. B
	MFG. APPR.	JLM	D5208	SHEET 4 OF 4
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	BLANKING PLATE	NTS
	DATE	15.06.11	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	